

Aero Design Ltd.**Work Order Control Sheet**

Work Order#: 2017-85 Date Opened: 09 May 2017 Title: Assembly
 Aircraft OEM: Bell Aircraft Model: 206B Product Type: Cargo Basket Product Model: Long Quantity: 1

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
 Additional Work Sheets (Standard Practice)
 Drawings (See List Below)
 Parts Distribution Sheet
 Sub Component Tags
 Completed Certification (Original)
 Time Sheet (R&D)
 Notes

Initial or N/A

KB
N/A
KB
KB
KB
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
 Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
81110	0	Basket	KB
81127	0	Placard	KB
70405	4	Walkway	KB
84255	2	Handle Installation	KB
84240	0	Lid Prop Installation	KB

Traveller

Install walkway on lid
 Install lid on basket body
 Re-tap mounting lug holes and install mount lugs
 Install handle brackets
 Install handle
 Install lid prop
 Install data plate

Initial or N/A

KB
KB
KB
KB
KB
KB
KB

Component Completion

Quantity Complete on This Work Order
 Quantity Incomplete on This Work Order
 Further Processing Required Before Release
 Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
 Serviceable (Green) Tag Completed
 In Process (Yellow) Tag Completed
 Unserviceable (Red) Tag Completed
 Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
 Non-Conformance Report Required
 Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
 Research and Development
 Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: K. BevansSign: K. BevansSCA: AD01Date: 09-May-17

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: J. ClarkeSCA: AD02Date: 10-May-17

Work Order closed by:

Print: J. ClarkeSign: J. ClarkeSCA: AD02Date: 10-May-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

206B Long AMF 73-04

Nomenclature: Handle assy. No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: 84261 Rev 1 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-58

Remaining Tasks to be Performed: Instal

Signature: David Dwyer

Date: April 28 / 2017 Lic. No. / SCA AD-05

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET LID (B206B long) No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 81112-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-58

Remaining Tasks to be Performed: NONE

Signature: Jff CLK.

Date: 09 MAY 2017 Lic. No. / SCA A002

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET BODY (B206B long) No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 8111-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-58

Remaining Tasks to be Performed: NONE

Signature: Jff Clh.

Date: 09 MAY 2017

Lic. No. / SCA A002



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	MS20001P4-9600	
Aircraft:	Multiple	Model: Multiple
Description:	Hinge	
Supplier:	Bisco	
Color:	N/A	
WO#:	N/A	

PO# 16030

Work Order: 2017-88

Material Tracking Sheet

1 of 2

Bell 206B

Date Opened: 09 May 2017

Long Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		81110-01	Cargo Basket Assembly	S/N 81101-07	
Step 1				<i>Lid Assembly</i>		
	1		81112-01	Basket Lid Assembly		2017-58
Step 1.a.	4		49205-14	Bumper	Argus Industries Bumper	
	A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	1		81127-01	Placard	0.063 Sheet, 6061-T6 Aluminum	2015-03
	4		CR3213-4-02	Cherry Rivet		16053
Step 1.c.	1		70405-01	Lid Step Modification		
(option)	1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	16017
	A/R		CR3213-4-02	Cherry Rivet		16053
	A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	1		82711-01	Basket Body Assembly		2017-58
	4		96710-01	Fitting	Alternate: Ancra 40088-14	
	8		NAS1149F0663P	Washer		
Step 3				<i>Hinge Installation</i>		
	1		MS20001P4	Piano Hinge	83"	15069
	8		CR3523-5-02	Cherry Rivet		16063
	A/R		CR3213-5-02	Cherry Rivet		16053
Step 4	1		84255-01	<i>Handle Installation</i>		
Step 4.a.	2		84267-01	Bracket	Delrin, 3/4" Sheet	2017-50
	4		AN3-11A	Bolt		
	8		NAS1149F0363P	Washer		
	4		MS21044N3	Nut		

Work Order: _____

Material Tracking Sheet

2 of 2

Bell 206B

Date Opened: _____

Long Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		2017-58
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	
	.. 2		AN3-12A	Bolt		
	.. 4		NAS1149F0363P	Washer		
	.. 2		MS21044N3	Nut		
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2017-38
	. 1		AN3-15A	Bolt		
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 6				Inspection	None	



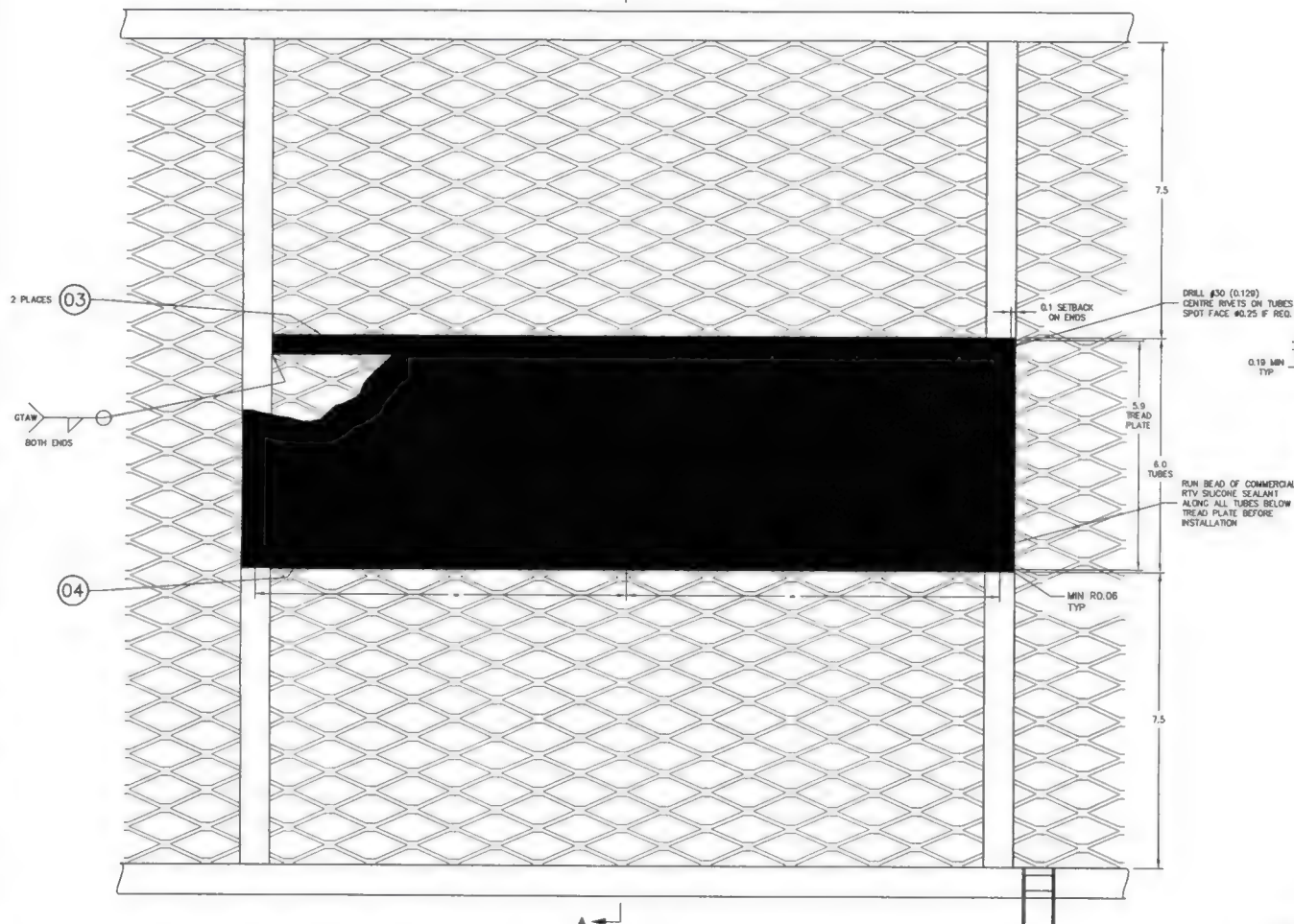
WO# _____

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

A



(01) BASKET LID ASSEMBLY

SECTION A-A

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	29/05/2014

NOTES:

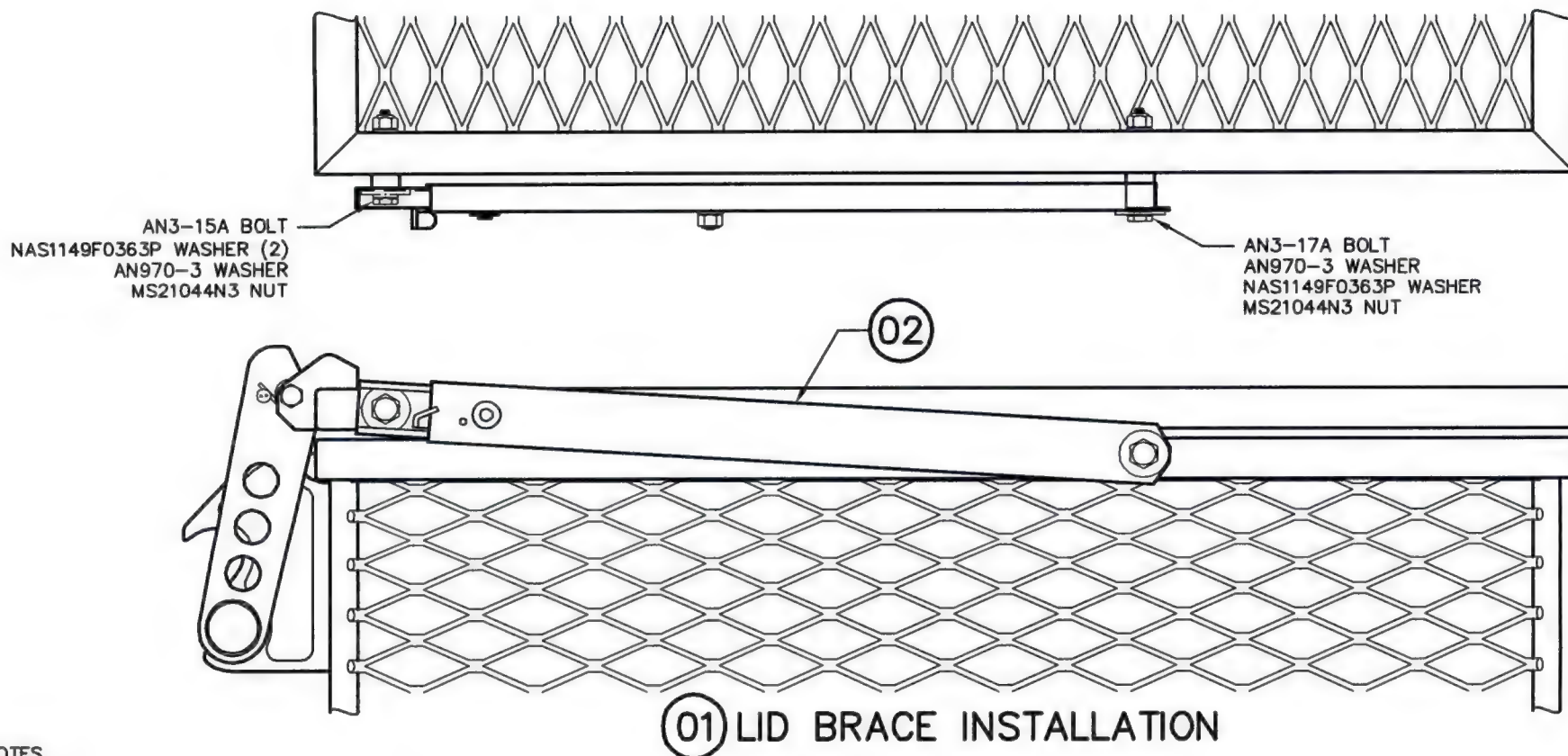
- THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
- TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
- WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02			
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL		0.063 TREAD PLATE
2	70405-03	03 TUBE	4130 STEEL COND. N	MIL-T-8738		0.5 X 0.035 WALL TUBE
1	SEE NOTE 1	02 BASKET LID ASSEMBLY				
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
				LIST OF MATERIALS		

BASIC CODE REF: HAS 523 C=COUNTERSINK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED BASIC CODES: BJ=MS20470AD BB=MS20426AD ARN=CR3213 ARN=CR3212		DASH NO. FOR DIAMETER N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE DASH NO. FOR LENGTH + INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURDON DATE: 21 SEPT 2008 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		AERO DESIGN LTD. 9806A MALASPINA ROAD POTWELL ROYER, BC, CANADA, V8A 0G5 TEL: 604-488-3279 www.aerodesign.ca	
CARGO BASKET LID STEP MODIFICATION				SCALE 1: 1.5 SHEET 1 OF 1		DIM. SIZE A1 70405	
				DIM. NO. 4			

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



NOTES

1. THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

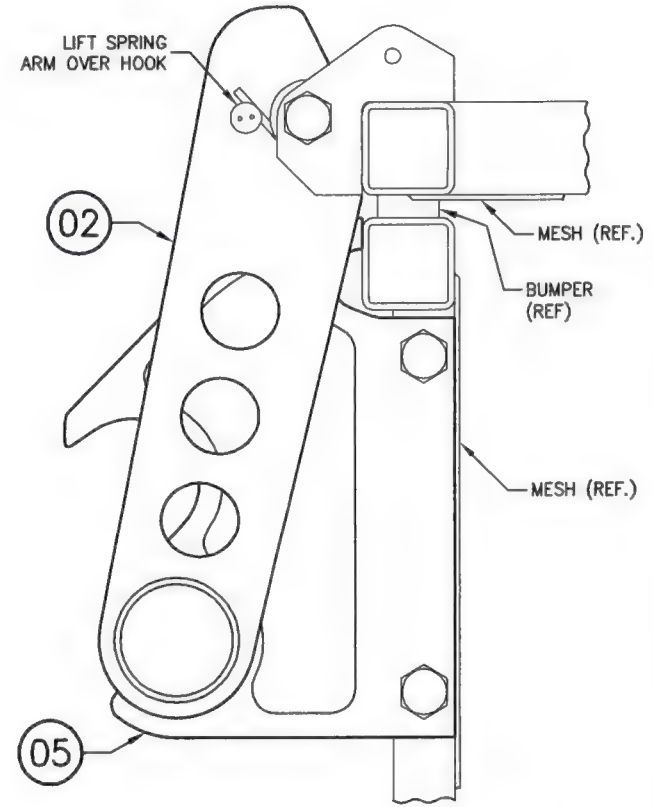
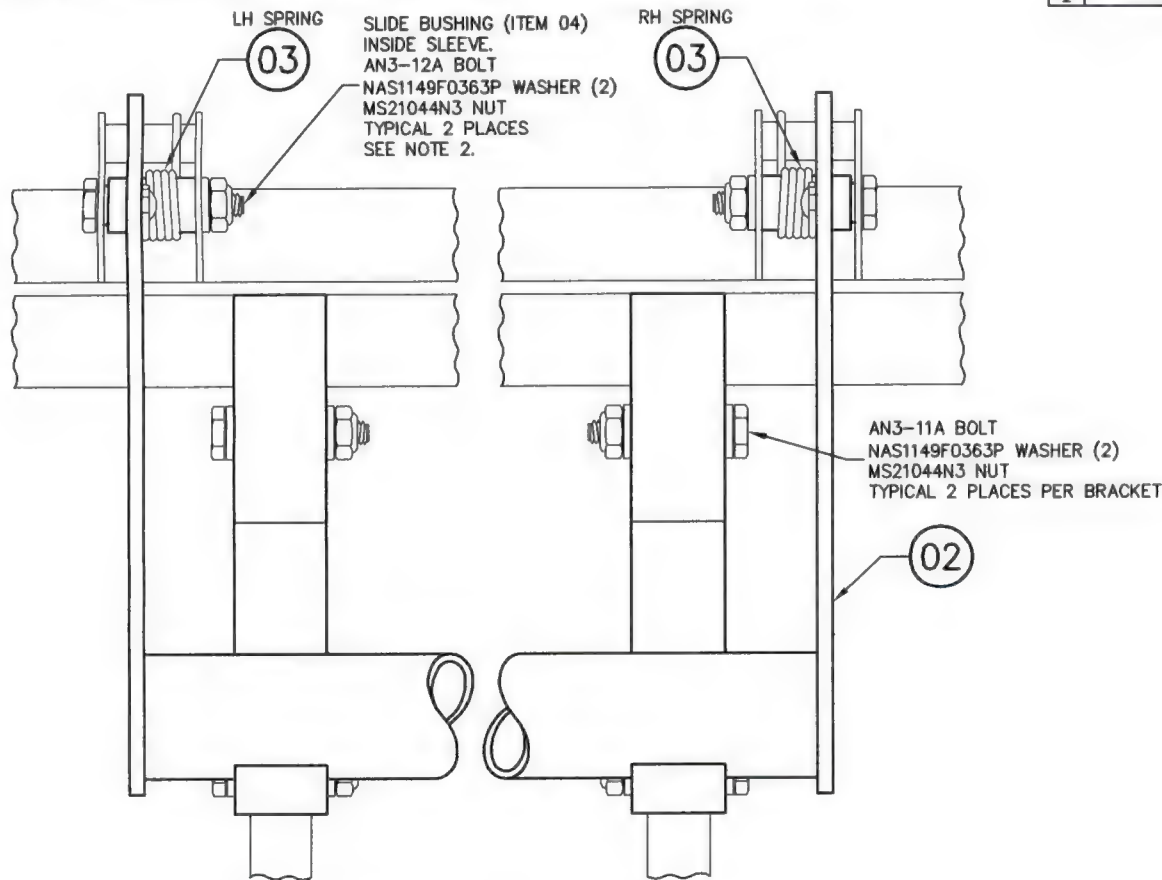
2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2370 www.aerodesign.ca			
HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION			
NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



01 HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	



AERO DESIGN LTD.

9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.463.8378 www.aerodesign.ca

**HELICOPTER CARGO BASKET
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

NOTICE

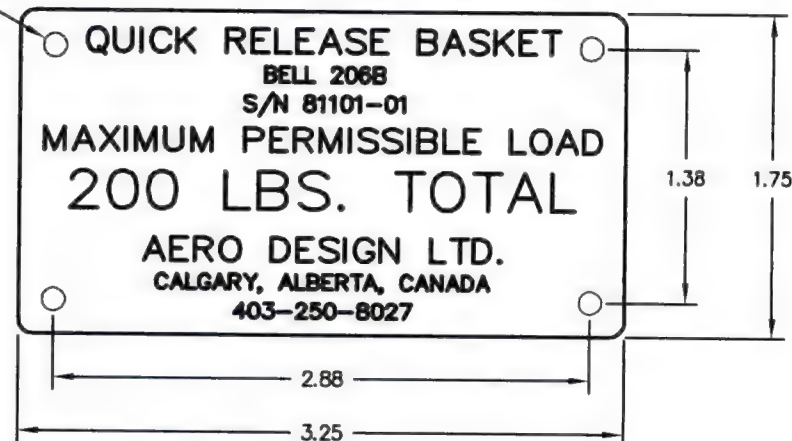
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1			

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
 "QUICK RELEASE BASKET" - 0.125 HIGH
 "BELL 206B" - 0.080 HIGH
 "S/N 81101-XX" - 0.080 HIGH
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
 "200 LBS. TOTAL" - 0.200 HIGH
 "AERO DESIGN LTD." - 0.125 HIGH
 "CALGARY, ALBERTA, CANADA" - 0.080 HIGH
 "403-250-8027" - 0.080 HIGH

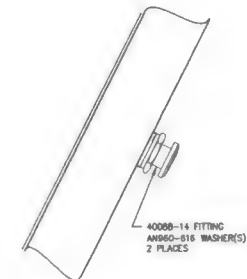
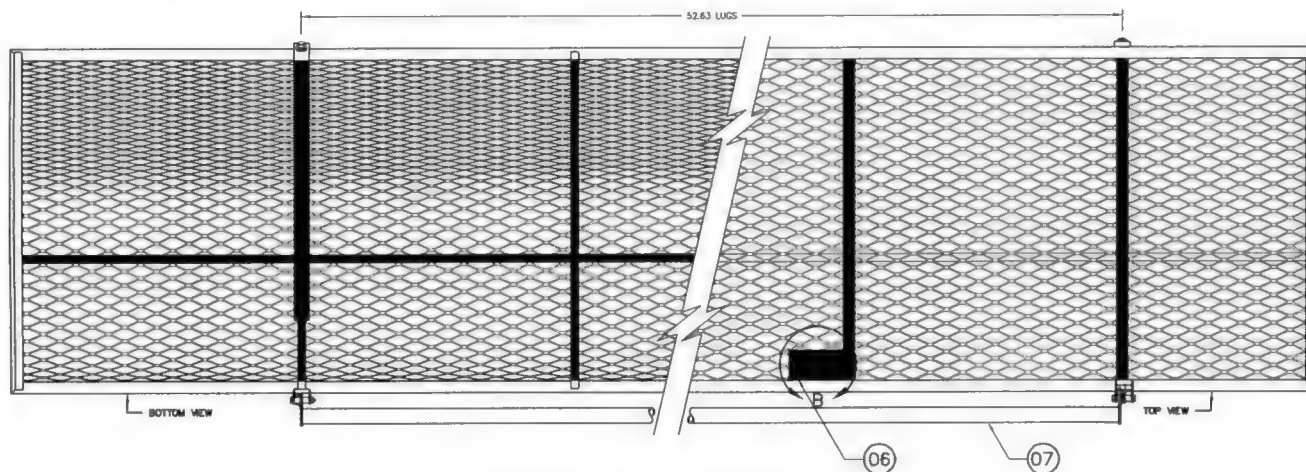
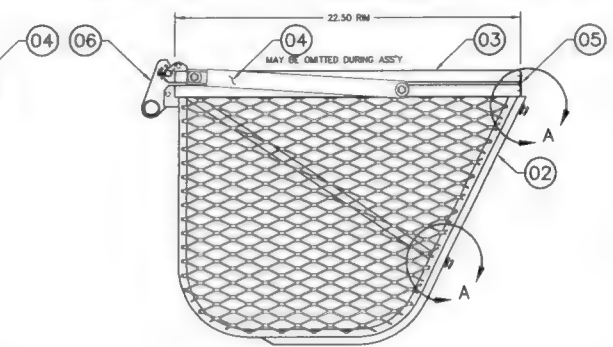
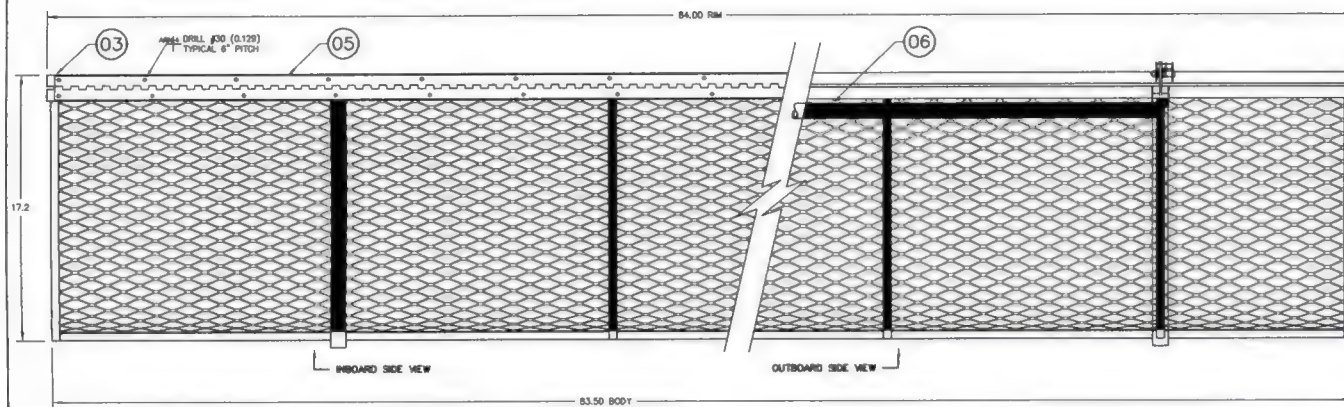
DRILL #30 (0.129)
4 PLACES



① PLACARD

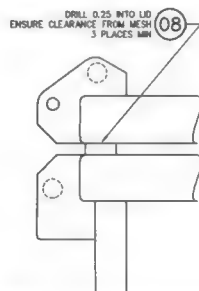
81127-01		01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET	
PART NO.		ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
LIST OF MATERIALS							
	APPROVALS		DATE	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net			
	DRAWN: JEFF CLARKE		29 JUNE 2007				
	CHECKED: E. BURGOIN						
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1			BELL 206B QUICK RELEASE CARGO BASKET PLACARD			
				SCALE 1 : 1		DWG. SIZE	DWG. NO.
			SHEET 1 OF 1	A1	81127	0	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0			

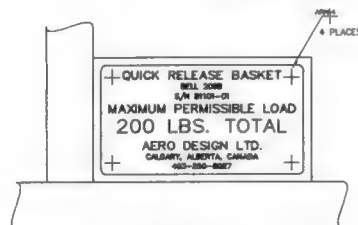


DETAIL A
SCALE 1 : 1
LOOKING AT LOWER ATTACHMENT, UPPER SAME
TYPICAL FWD AND AFT

NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.



BUMPER INSTALLATION



DETAIL B
SCALE 1 : 1
LOOKING AT PLACARD BRACKET

① CARGO BASKET ASSEMBLY

A/R	4	40058-14	FITTING	ANGRA			
A/R	3	CR3215-4-02	CHERRY RIVET				
	3	40205-14	08 BUMPER	ARGUS INDUSTRIES			
	1	81127-01	07 PLACARD				
	1	36225-01	06 HANDLE BAR INSTALLATION				
	1	MS2001P4	05 PLANO HINGE				
	1	36280-01	04 BRACE ASSEMBLY				6 FEET LONG
	1	81112-01	03 LID ASSEMBLY				
	1	81111-01	02 BASKET BODY ASSEMBLY				
	1	81110-01	01 CARGO BASKET ASSEMBLY				
D1		PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY					100% OF MATERIAL		

BASIC CODE REF. NAS 523		DASH NO. FOR DIAMETER I=INCH, HEAD OR EAR SIDE W=INCH, HEAD OR EAR SIDE		APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURDON		DATE 09 OCT 2008		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DASH 500M 3515 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2C 6K7 Tel: (403) 240-8987 Fax: (403) 240-8988 aerodesign@compuserve.net	
C=COUNTERSUNK D=DIMPLE DASH NO. FOR LENGTH		DASH NO. FOR LENGTH		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:		CELL 206B QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY		SCALE 1 : 4 SHEET 1 OF 1	
BASIC CODES: BJ = M202470AD BJ = M202470AD ARH = CR3213 ARH = CR3212		+ ⊕ INSTALL NEW RINET + ⊕ REMOVE/REPLACE RINET - ⊖ EXISTING RINET		DECIMALS X.XX ±0.010 X.X ±0.3 X.X ±0.1		ANGLES ±1/2°		DWG. NO. A1 81110 0	

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0177
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-85
6. Item 1.	7. Description Cargo Basket Ass'y	8. Part Number 81110-01	9. Qty. 1	10. Serial/Batch No. 81101-07	11. Status/Work New
12. Remarks Modified with walkway on lid IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature 14c. Approved Organization Number	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 10 May 2017		14d. Name 14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

BAILEY HELICOPTERS

CARGO BASKET ASSEMBLY - COMMON

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2017-85

Date Open: 09 May 2017

1. Lid Assembly

KB

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

KB

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

KB

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ???. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

KB

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

6. Final Inspection

Dual inspection by a different person than assembled the basket.

a. Check for general condition and correct assembly:

- i. Bolts are tight
- ii. Rivets are installed correctly
- iii. Handle operates correctly
- iv. Lid brace operates correctly

b. Check that PO/WO numbers have been recorded.

AD
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